

# Work Order ID 83922

April-27-12 11:21:32 AM

**\*83922\***

Page 1

Item ID: D4151-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Basket Instl Stud  
 Start Date: 27/04/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 11/05/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLT Date: 12/04/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

110 0.00  
**\*110\***  
 Doosan  
 Doosan Lathe  
 Memo  
 1-Mill as per folio FA953 & dwg,  
 FOLIO REV: C  
 DWG REV: 7  
 2-Deburr as required  
 12 1  
 (PTO)

120 0.00  
**\*120\***  
 QC  
 Quality Control  
 Memo  
 QC2- Inspect parts off machine FAI/FAIB  
 12 1

W/O: 83922		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4151-5 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No QAC Date: 12/05/23  
12-1424 Resolution: Scrap Disposition: SCRAP QA: N/C Closed: Q Date: 12/5/23

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 25.08						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.09	110	STOCK BAR HAD DEEP GAUGE SHOWING ON MACHINED PART. QUANTITY 1 ONLY.	↓ 12.05.09 Q51042	SCRAP PART & Replace. same label	↓ 12/5/9	↓ 7/6/19	↓ 12.05.09 Q51042	↓ 7/6/19

NOTE: Date & initial all entries

**\*83922\***

Page 2

**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 27/04/2012    **Start Qty:** 12.00    **\*12\***

**Cust Item ID:**

**Required Date:** 11/05/2012    **Req'd Qty:** 12.00    **\*12\***

**Customer:**

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Operation	Description
1	Start of the program
2	Initialisation of variables
3	Calculation of the sum of the first 10 natural numbers
4	Output of the result
5	End of the program

### Set Up/ Run Hours

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

140

Identify as per dwg & Stock Location: 103 0.00

0.00

**\*140\***

### Packaging

## Memo

0.00

### Packaging

150

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

MF 12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 11:21:37 AM

Page 1

Work Order ID: 83922

\*83922\*

Parent Item: D4151-5

\*D4151-5\*

Parent Item Name: Fwd Basket Instl Stud

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B  
11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R1.000

Purchased

No

110

f

39.3152

0.25

3.157895

\*M303R1 000\*

\*\*

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

39.31515789

120866

12

121070

3.31515789

121282

24

3.4 RT 52 12/3/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

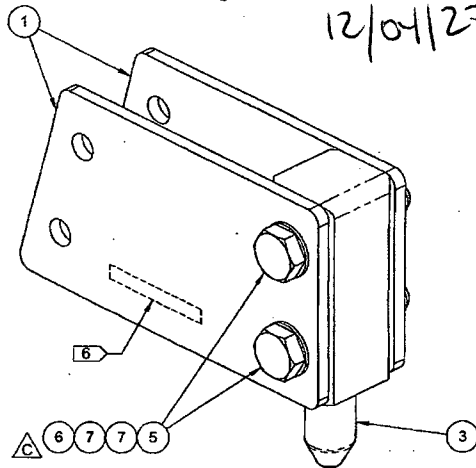
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

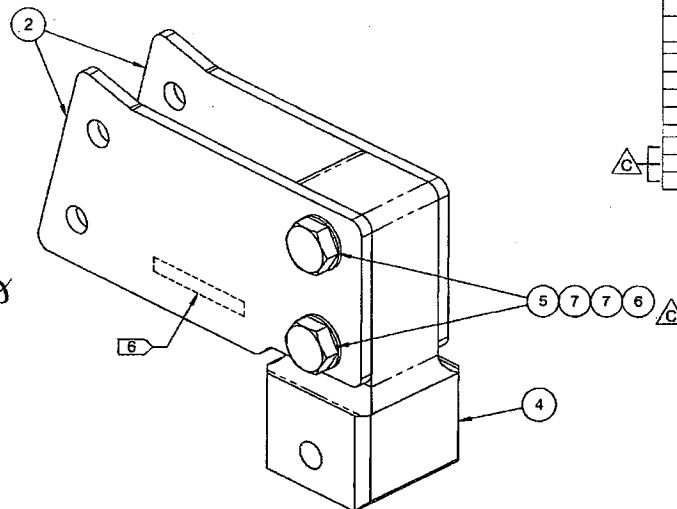
**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83927 MLC  
12/04/23



**D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)**



**D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)**

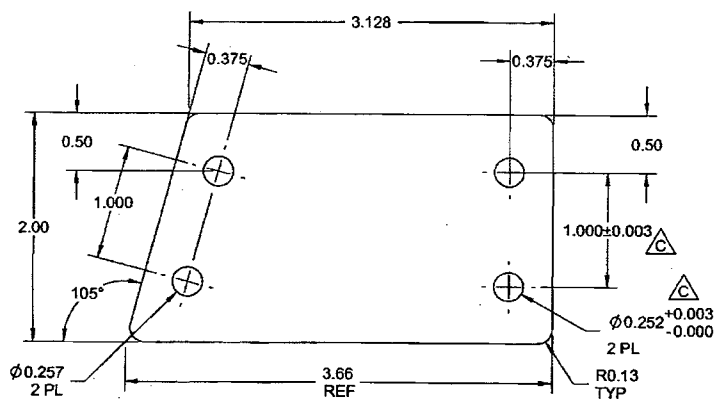
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

RELEASED  
2011-01-08  
MR

C	AM4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C5-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL	MB	10.12.14
B	ADDED D4151-5-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4151</b> <b>BASKET FWD HARDPOINT</b> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS A PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

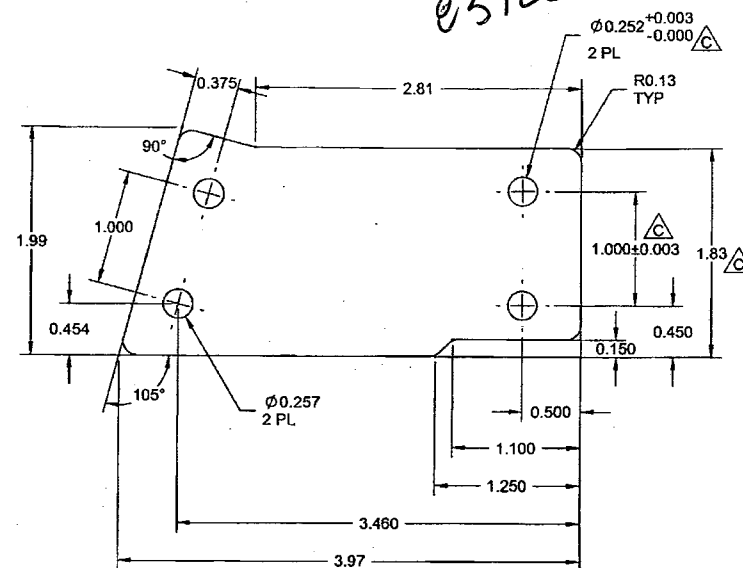
NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT:  
- D4151-041 = 0.88 lbs  
- D4151-043 = 1.17 lbs





0.125  
REF

**D4151-1 LOWER HARDPOINT PLATE**




0.125  
REF

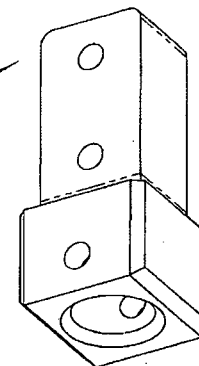
**D4151-3 UPPER HARDPOINT PLATE**

# NOTES:

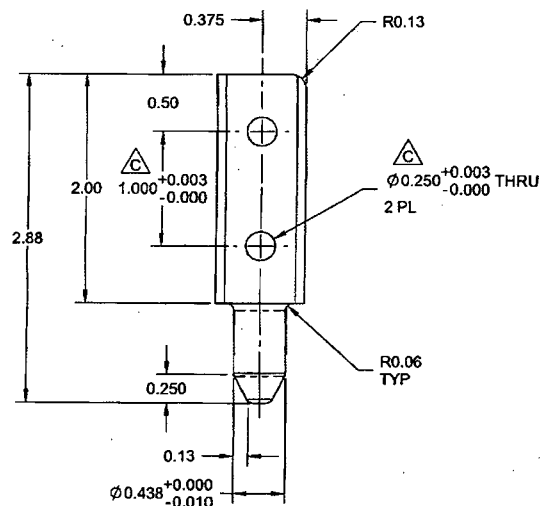
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:  
- D4151-1 = 0.24 lbs  
- D4151-3 = 0.23 lbs

DESIGN			<b>DART AEROSPACE LTD</b>	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			<b>D4151</b>	SHEET 2 OF 3
APPROVED			TITLE	SCALE
DE APPR.			<b>BASKET FWD HARDPOINT</b>	NTS
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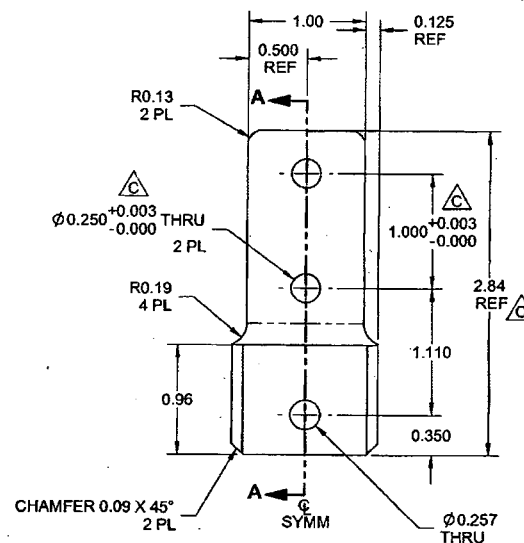
RELEASED  
R 2011-01-18  
JMD



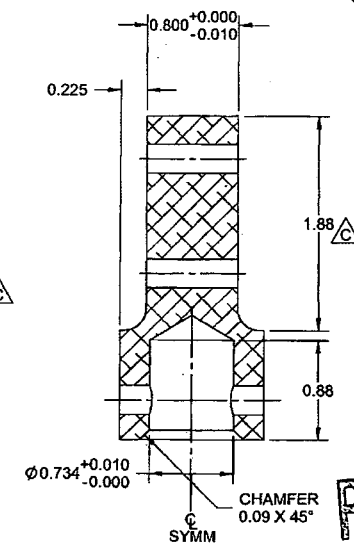
83922



### D4151-5 FWD BASKET INSTL STUD (LOWER)



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**




**SECTION A-A**

RELEASED  
2011-06-23  
RELEASED

NOTES:

- NOTES:
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R  
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
  - 7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

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CHECKED		DRAWING NO.	REV.
MFG. APPR.		<b>D4151</b>	SHEET 3 OF
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